

Date: Wednesday, 07/01/2009 1:36:32 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 44471 3
Estimate Number : 12578
P.O. Number :
This Issue : 07/01/2009 S.O. No. :
Prsht Rev. : NC
First Issue : 11 Type : MACHINED PARTS
Previous Run : 41067
Written By : Julie Dawson 09-01-09
Checked & Approved By :
Comment :
Part Number : D3560041
Drawing Number : D3560 REV D
Project Number : N/A
Drawing Revision : D
Material :
Due Date : 23/01/2009
Qty: 5 Um: Each
Est Rev:A New Issue 07.05.24 EC
est rev B ECN 987 07.10.09 EC verified by: DD
Est Rev:C ECN1048 07-12-18 DD verified by: EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B0500X05000

6061-T6 Bar .500 x 5.00



Comment: Qty.: 1.4648 f(s)/Unit Total: 11.7180 f(s)
6061-T6 Bar 0.50" x 5.00"
Batch: M1105 SB

Jul 09/01/19

2.0

BAND SAW

BAND SAW



Comment: BAND SAW
Cut blanks 16.750" long

Jul 09/01/19

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA693 Rev: AA & Dwg D3560 Rev: D

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

LF 09/01/21 (8)

LF 09/01/21

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 44471

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6.0

D35921

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLATE

Batch: B47015

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad) *th*
- 2- set up bracket and arm on jig *th*
- 3- preheat bracket and arm with torch *th*
- 4- clean before welding with brush *th*
- 5- set up machine to 135 amps *th*
- 6- weld across bottom and top ends *th*
- 7- reheat with torch (65 deg C) *th*
- 8- on one side weld from bottom to top half way *th*
- 9- same for other side (half way) *th*
- 10- from half way point weld the rest of the first side (ease off pedal near end) *th*
- 11- same for remaining side (ease off pedal near end) *th*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Date: Wednesday, 07/01/2009 1:36:32 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 44471

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 09/06/10

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-06-10

12.0

D2808

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Spacer

batch:

B41708

09/06/10

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

09/06/10

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/06/10

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

WFA

09-06-10

16.0

QC21

FINAL INSPECTION/W/O RELEASE



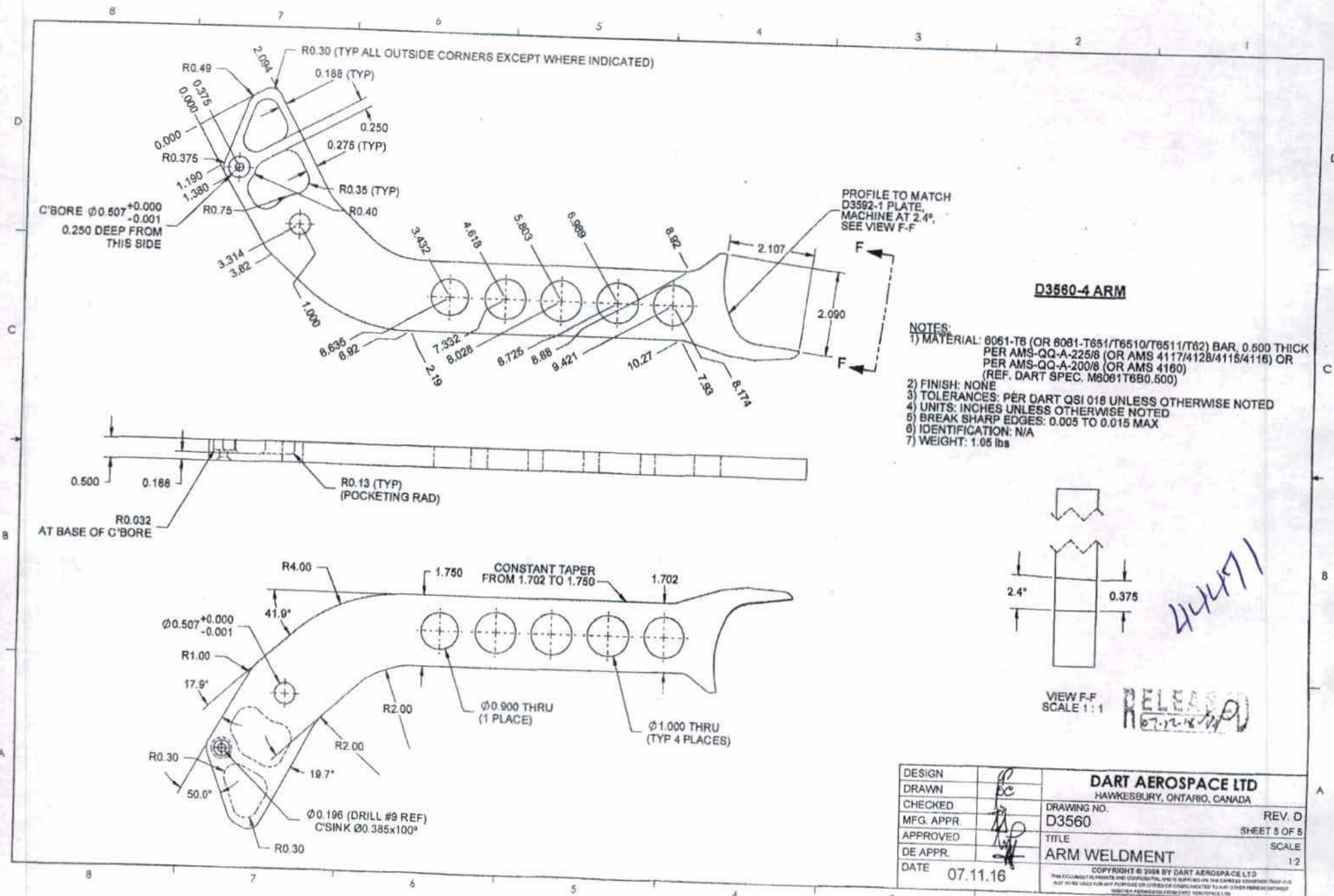
Comment: FINAL INSPECTION/W/O RELEASE

09/06/11

Job Completion



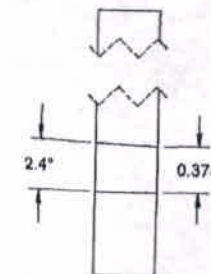
mf 09-06-10



D3560-4 ARM

NOTES

- NOTES:
1) MATERIAL: 8061-T8 (OR 8061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4180)
(REF. DART SPEC. M6061T8S0.500)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.05 lbs

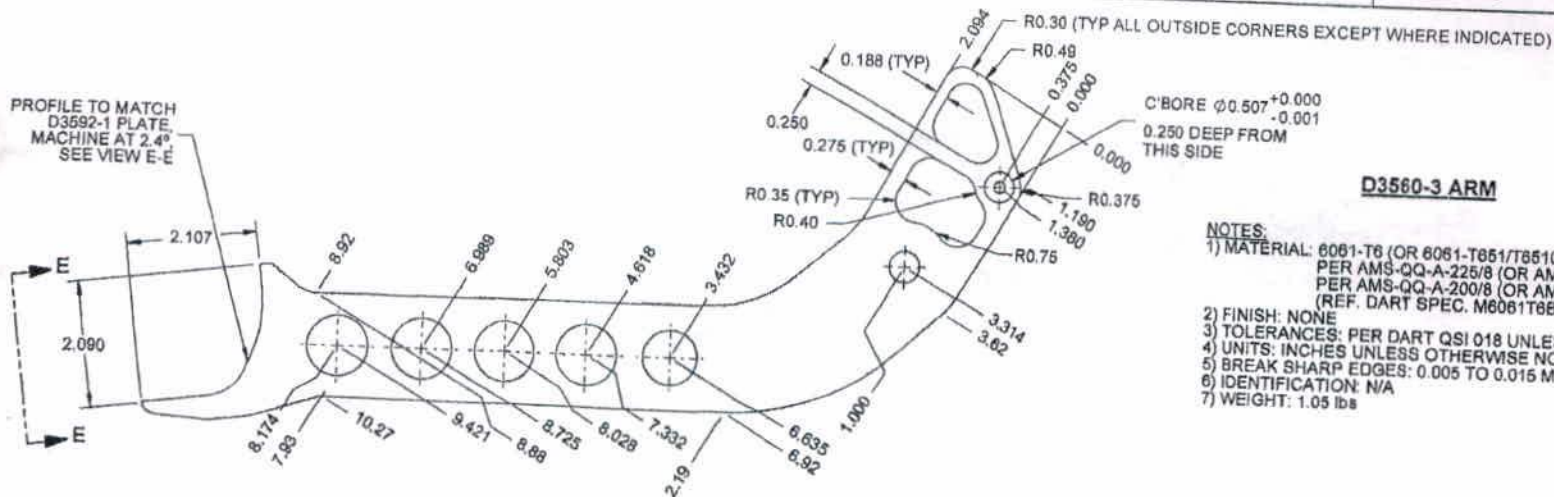


VIEW F-F
SCALE 1:1

RELEASED
107-12-18-119

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3560	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:
DATE	07.11.16	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, WHICH REMAINS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

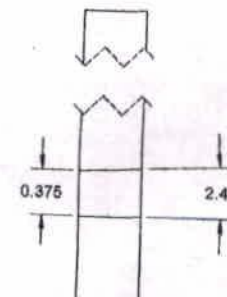
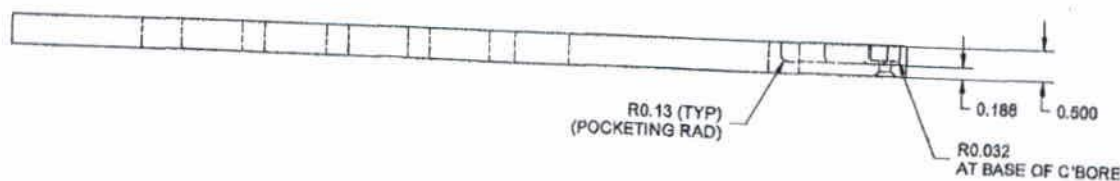
PROFILE TO MATCH
D3592-1 PLATE
MACHINE AT 2.4°
SEE VIEW E-E



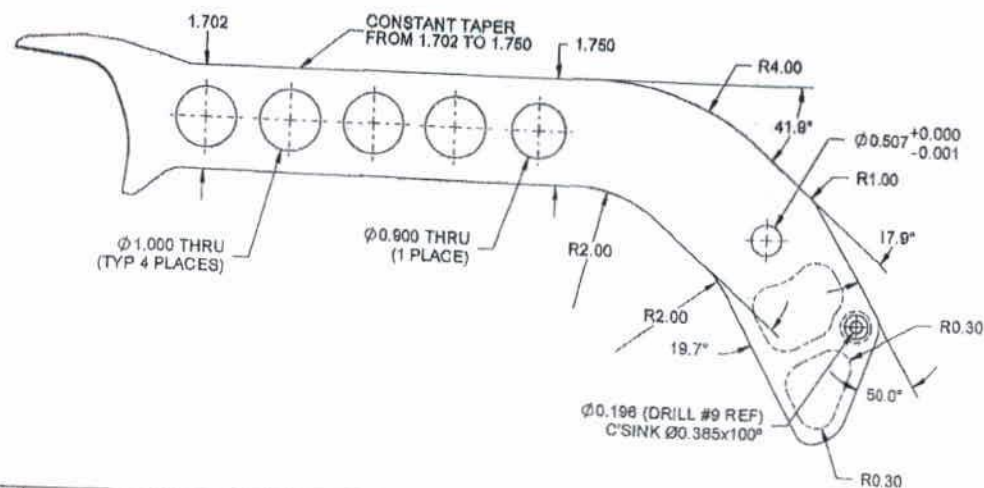
D3560-3 ARM

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4180)
(REF. DART SPEC. M6061T680.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs

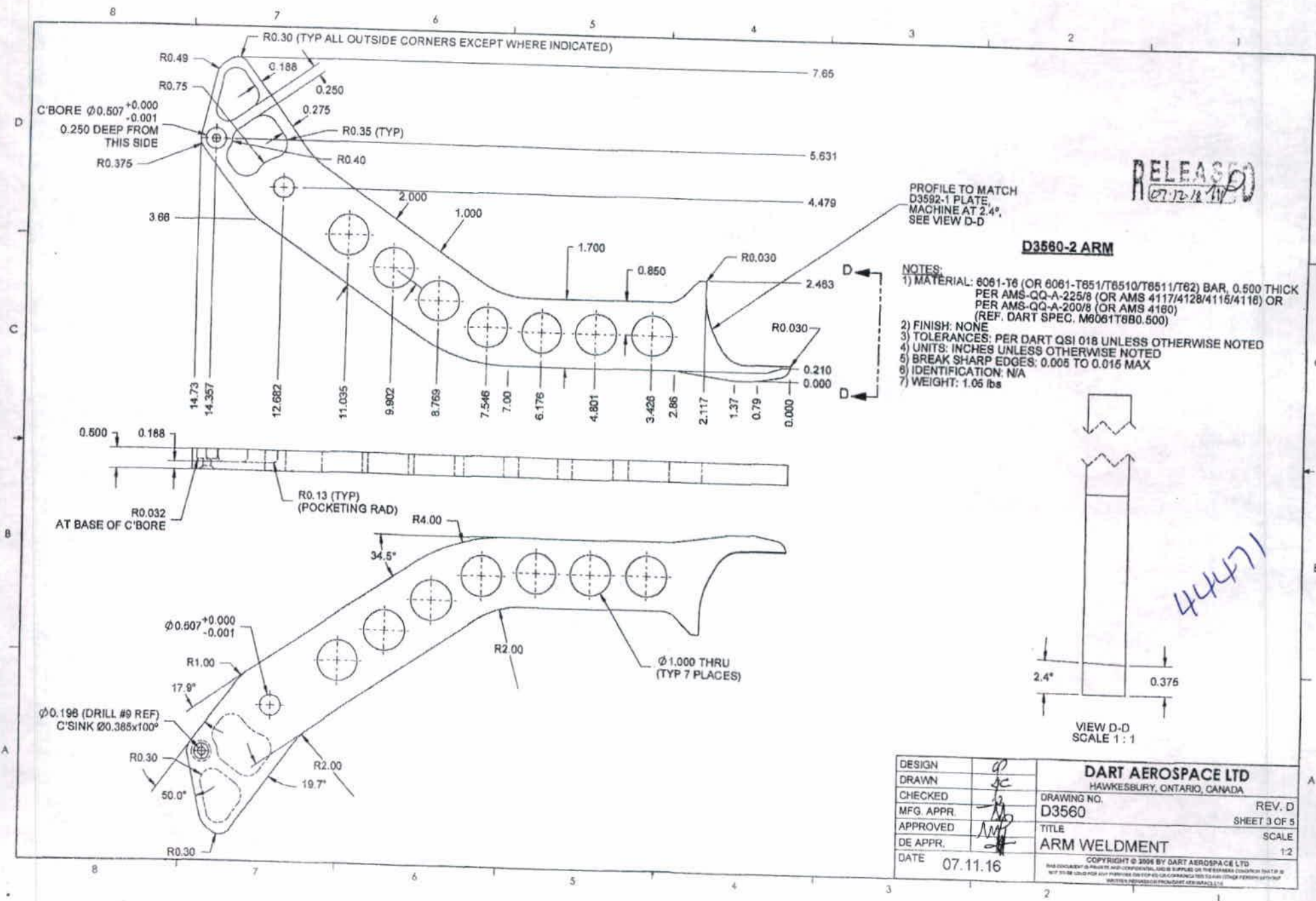


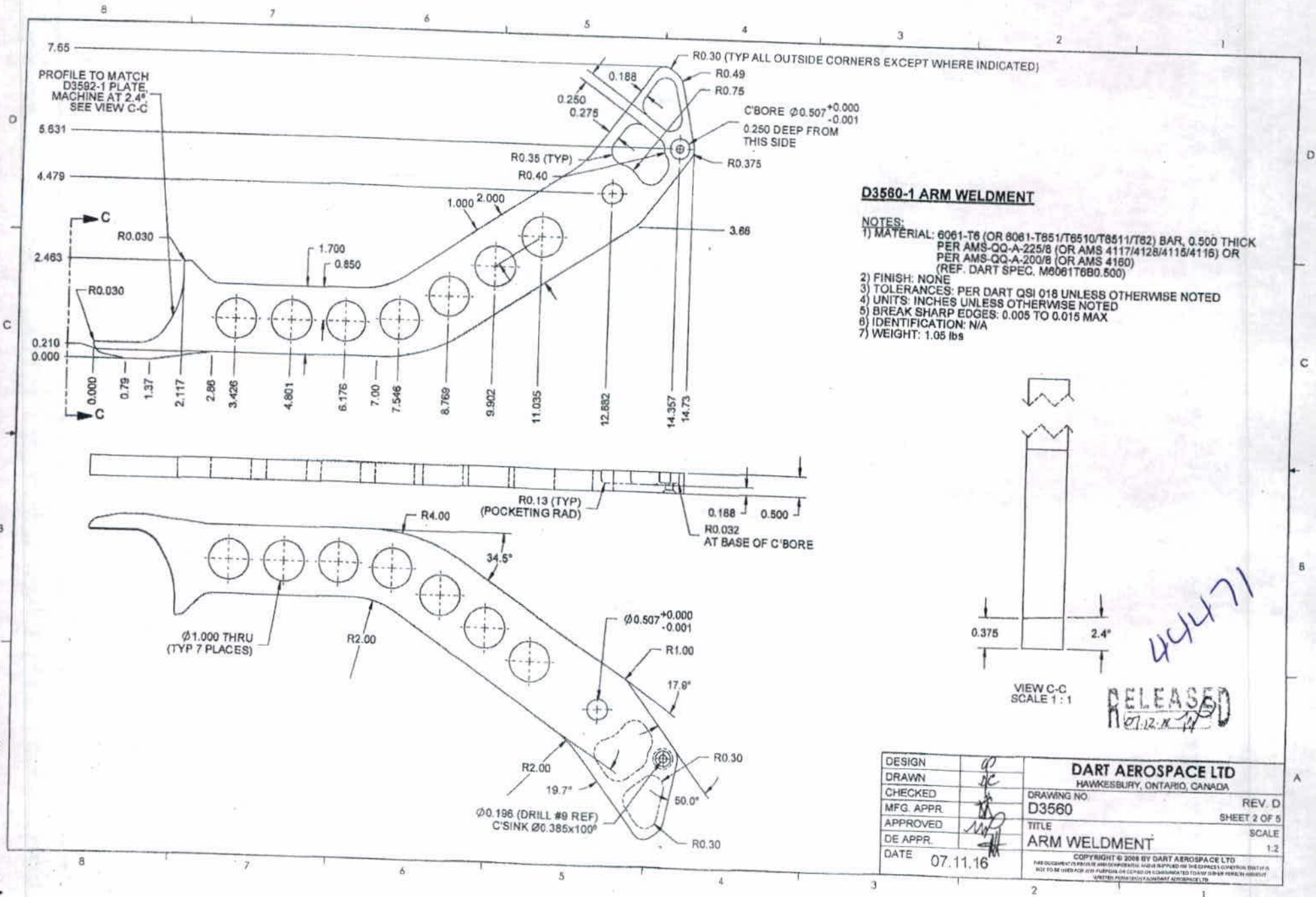
VIEW E-E
SCALE 1:1



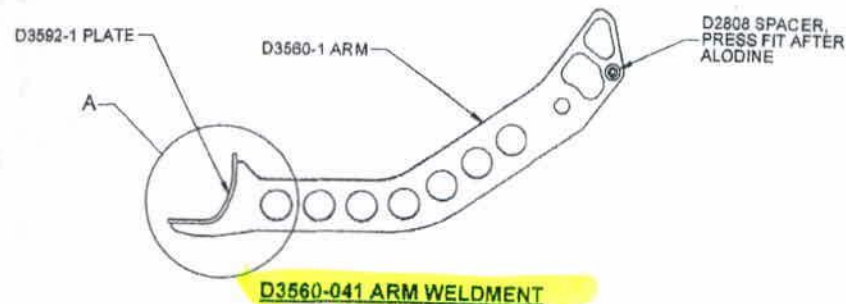
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07.11.16

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DRAWN	40	HAWKESBURY, ONTARIO, CANADA	
CHECKED	40	DRAWING NO.	REV. D
MFG. APPR.	40	D3560	SHEET 4 OF 5
APPROVED	40	TITLE	SCALE
DE APPR.	40	ARM WELDMENT	1:2
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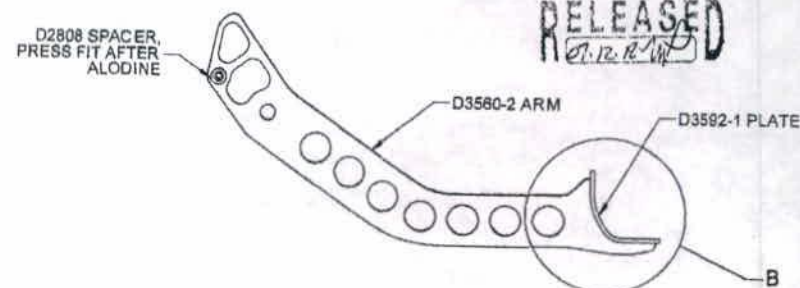




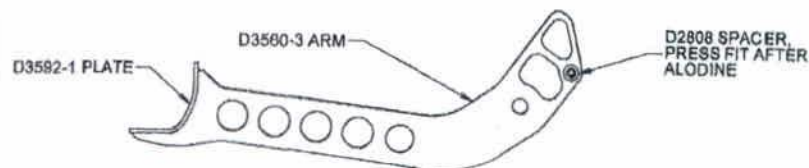
RELEASED
27.12.2016



D3560-041 ARM WELDMENT



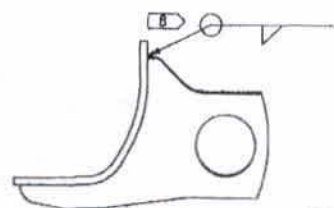
D3560-042 ARM WELDMENT



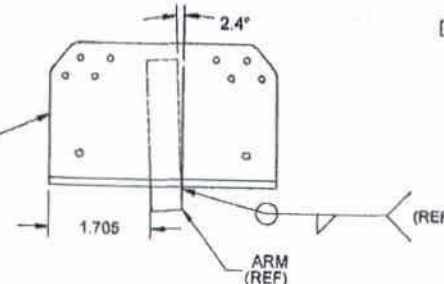
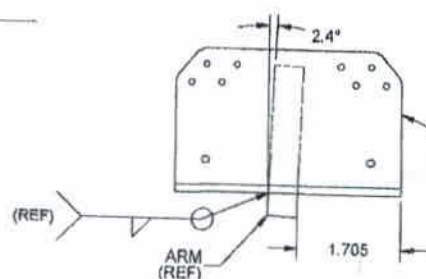
D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT



DETAIL A
SCALE 1:2



DETAIL B
SCALE 1:2

PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.23 lbs (TYP)
 8) WELDING: PER DART QSI 004

DESIGN	D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
DRAWN	C	REMOVE POWDER COAT	CP	07.06.10
CHECKED	B	REDESIGN AS WELDMENT; ADD POCKETS	CP	07.01.15
MFG. APPR.	A	NEW ISSUE	CP	06.00.25
APPROVED	REV.	DESCRIPTION	BY	DATE
DE APPR.				
DATE	07.11.16			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3560	REV. D SHEET 1 OF 5
TITLE ARM WELDMENT	SCALE 1:4

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